Date: Thursday, 3/30/2006 8:30:39 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: NUT PLATE ASSEMBLY
Job Number	: 26410		
Estimate Number	: 11054		
P.O. Number	: N/A	**Part Number**	: D2873045
This Issue	: 3/30/2006 **S.O. No.** : N/A	**Drawing Number**	: D2873 REVA
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: A
Previous Run	: N/A	**Material**	: N/A
Written By	: See Comment Below	**Due Date**	: 4/10/2006 **Qty:** 30 **Um:** Each
Checked & Approved By	: MJ 06.03.30		
Comment	: Est A05.0[illegible]13 New issue KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0375X01000	6061T6 BAR

Comment: Qty.: 0.2363 f(s)/Unit Total : 7.0875 f(s)
6061T6 BAR
Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
(M6061T6B0.375x01.000)
Identify for D2873-5
Batch: M18250 J.G 06/04/11 30

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks: 1.000" x 0.375" x 2.700" long JG 06/04/16 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA and Dwg D2873
Identify as D2873-5 Dwg Rev A Folio Rev AA

JG 06/04/17 30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE JG 06/04/17 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 8:30:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** NUT PLATE ASSEMBLY

Job Number: 26410 **Part Number:** D2873045

Job Number:

Seq. #:	Machine Or Operation:	Description :	
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		06/04/17 30
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2- C'sink as per Dwg D2873		FF 06-04-24 30
7.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP		06-04-25 30
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		HM 06-04-27 30
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
	Comment: INSPECT CHEMICAL CONVERSION		SB 06/05/02 30
10.0	MS20426AD46	Rivet	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s) Rivet Pick; Qty Part Number Description Batch 4 MS20426AD4-6 Rivet M2930		FF 06.05-02 30
11.0	MS21075L5	Nut Plate	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s) Nut Plate Pick; Qty Part Number Description Batch 2 MS21075L5 Nut Plate M18136		FF . 06.05.02 30

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ✓ **Date:** 06/05/04

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 8:30:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** NUT PLATE ASSEMBLY

Job Number: 26410 **Part Number:** D2873045

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Assemble as per Dwg D2873
2-Identify as D2873-045

FF 06.05.02 30

13.0	QC5	INSPECT WORK TO CURRENT STEP

06.05.04 30

Comment: INSPECT WORK TO CURRENT STEP

14.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 392

06/5/4 (30)

15.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

(30) 06/05/04

Job Completion

06.55.04

Form: rprocess

Dart Aerospace Ltd

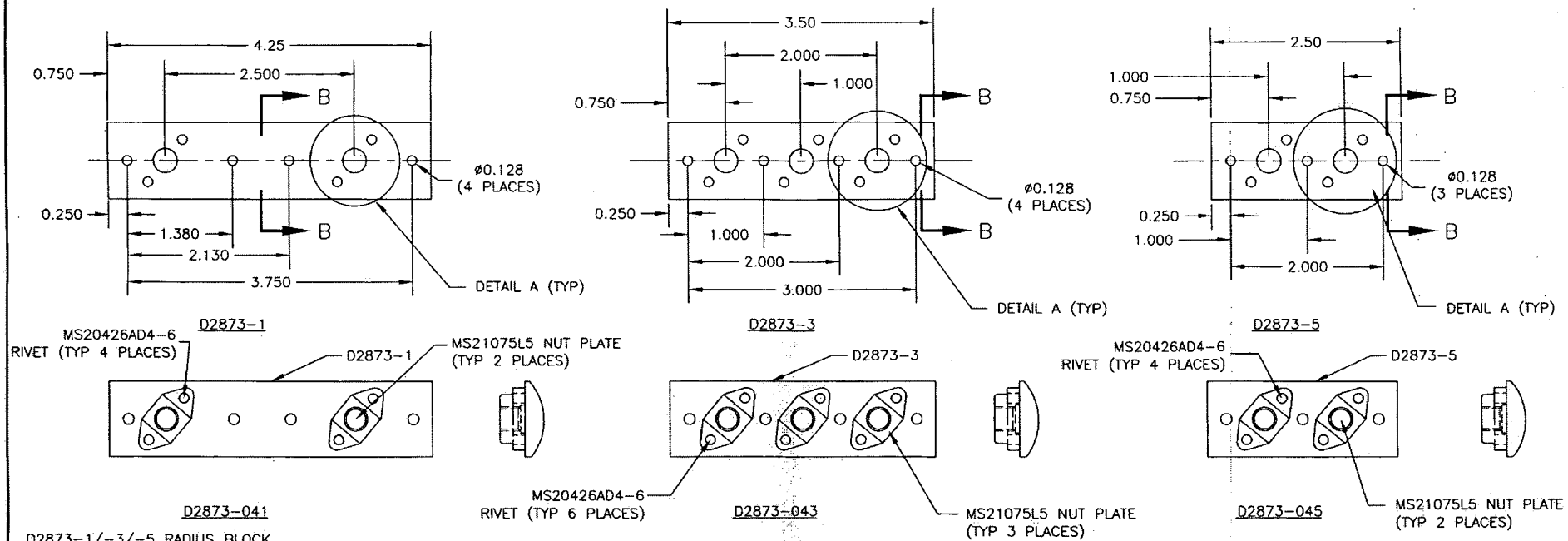
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2873-1/-3/-5 RADIUS BLOCK

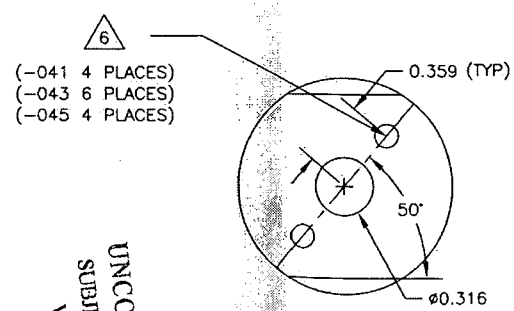
1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR
6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE INCHES
5) BREAK ALL SHARP EDGES 0.010 TO 0.020
6) ø0.128 PILOT + C'BORE CURVED SIDE ø0.230X0.125 DEEP + C'SINK CURVED SIDE ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

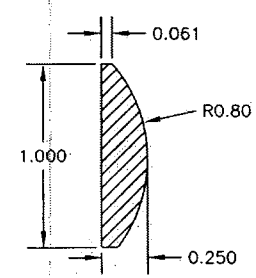
1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED 05.07.26

A	05.07.26	NEW ISSUE	
DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873	REV. A SHEET 1 OF 1
DATE 05.07.26		TITLE RADIUS BLOCK	SCALE 4:5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26410

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DART AEROSPACE LTD	Work Order:	26410
Description: RADIUS BLOCK	Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	±.030	2.501	—			
1.008	±.005	1.000	—			
0.750	±.005	0.750	—			
0.256	±.005	0.250	—			
1.000	±.005	1.000	—			
2.000	±.005	2.000	—			
Ø0.128	±.005 .001	Ø0.128	—			
Ø0.316	±.006 .001	Ø0.317	—			
1.000	±.010	1.002	—			
0.061	±.010	0.058	—			
0.250	±.010	0.249	—			

Measured by:		Audited by:		Prototype Approval:	
Date:	06/04/17	Date:	6/6/17	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	